

IN THE CLAIMS

1. (currently amended) A device for producing a breaker ply having a longitudinal axis, a breaker ply length and mutually parallel cords at a pre-set cord angle to the longitudinal axis, wherein the device comprises:

[[[-]]] an extrusion device for producing at least one continuous rubber strip having substantially mutually parallel embedded longitudinal cords having a ~~centre-to-centre~~ ~~center-~~

~~to-center~~ distance and having a strip width;

[[[-]]] a first transport device for transporting the continuous rubber strip in the direction of the longitudinal cords;

[[[-]]] a second transport device for transporting the breaker ply in the longitudinal direction of the breaker ply in a transport direction, comprising a support surface for the breaker ply;

[[[-]]] a first cutting device for cutting bands from the continuous strip diagonally at the cord angle;

[[[-]]] a building drum for receiving the breaker ply coming from the second transport device, wherein the building drum has an axis of rotation,

wherein the first transport device is adapted for transporting the continuous strip to the second transport device, the second transport device is positioned with its transport direction at an angle having the size of a cord angle to the direction of the longitudinal cords, the longitudinal direction of the breaker ply substantially corresponds to the transport direction, and the building drum is positioned with its axis of rotation substantially transverse to the second transport direction, wherein the second transport device is provided with a first drive and a first ~~operator for operating~~ ~~control device for controlling~~ the first drive, wherein the ~~operator~~ ~~control device~~ is adapted for controlling the drive for adjustably moving the support surface of the second transport device with an adjustable

transfer distance for positioning the next band, or a transport distance for transporting the breaker ply towards the building drum; and

wherein the control device comprises a memory for storing the strip width, the center-to-center distance between the longitudinal cords and the breaker ply length and a calculating unit for calculating a band number, being the necessary number of bands to form a breaker ply, and the transfer distance based on the center-to-center distance, the strip width and the breaker ply length.

2. (Canceled)

3. (Previously presented) The device according to claim 2, wherein said transfer distance is calculated for each breaker ply again.

4. (currently amended) The device according to claim 3, wherein the operator control device comprises a counter for counting the number of bands placed, and a decision routine for deciding to transport the breaker ply to the building drum when the number of bands placed equals the band number, or when the breaker ply length has been reached.

5. (currently amended) The device according to claim 1, further comprising a measuring unit for measuring the length of the breaker ply on the support surface of the second transport device during making the breaker ply, connected to the operator control device.

6. (currently amended) The device according to claim 2, wherein the operator control

device is adapted for adjusting the transfer distance based on the measured length of the breaker ply during manufacturing it, the set breaker ply length and the set ~~centre-to-centre~~
~~center-to-center~~ distance between the longitudinal cords.

7. (currently amended) The device according to claim 1, wherein the first transport device ~~furthermore~~ comprises a placement device for picking up the continuous rubber strip or bands from the first transport device and placing it or them on the support surface of the second transport device.

8. (Previously presented) The device according to claim 7, wherein the placement device is positioned after the cutting device for placing the continuous rubber strip on the support surface.

9. (Previously presented) The device according to claim 7, wherein the placement device is provided with a splicer for splicing the bands together into a breaker ply.

10. (Previously presented) The device according to claim 1, wherein the second transport device comprises a transfer device for transferring the support surface to the building drum for placing the breaker ply against the building drum.

11. (currently amended) The device according to claim 1, wherein the second transport device comprises a first conveyor and a second conveyor, wherein the conveyors are positioned with their transport directions in line, wherein the first conveyor comprises a support surface for receiving the bands or continuous rubber strip and a drive connected to the

operator control device.

12. (Previously presented) The device according to claim 11, wherein the second conveyor comprises a support surface for supporting the breaker ply, wherein the support surface of the second conveyor is movable from a first position, in which the support surface of the first conveyor lies in line with the support surface of the second conveyor, to a second position, in which the support surface rests against the building drum.

Claims 13 - 16. (Canceled)

17. (currently amended) The device according to claim 1, furthermore comprising a third transport device, having its transport direction substantially parallel to the transport direction of the second transport device, and a second cutting device for cutting the continuous rubber strip substantially parallel to the first cutting device.

18. (Previously presented) The device according to claim 17, wherein the second cutting device is arranged for cutting between the second and third transport device.

19. (Currently amended) The device according to claim 17, wherein the third conveyor transport device comprises a support surface for a breaker ply, situated adjacent to and consecutive to the support surface of the second conveyor.

20. (currently amended) The device according to claim 1, further comprising ~~furthermore provided with~~ a main operation device, wherein the main operation device

comprises a memory and a data processing unit, an input unit for setting the ~~centre-to-centre~~
center-to-center distance between the longitudinal cords and a breaker ply length and software
for reading a set ~~centre-to-centre~~ center-to-center distance between the longitudinal cords and
the breaker ply length.

21. (currently amended) The device according to claim 20, wherein the software is
provided with a distance routine for calculating the target mutual distance between the bands
from the band width, the ~~centre-to-centre~~ center-to-center distance between the longitudinal
cords and the set breaker ply length.

22. (currently amended) The device according to claim 21, wherein the software is
furthermore provided with operation routines for operating the placement device for
transferring a partly formed breaker ply, wherein the transfer is calculated by means of the
distance routine for calculating the mutual distance between the bands.

Claims 23 - 40. (Canceled)